

CLAIMS

1. A method of making an injection moulded container for housing information storage media, the container comprising a base portion and a lid portion moveable about a spine portion between an open and a closed configuration and holding means for holding the information storage media within the container, the method involving the use of an injection moulding tool comprising two carrier units each of which is adapted to receive a plurality of inserts therein which together define a cavity for forming the container: a first set of the inserts for forming a first set of features of the container being formed of a first material and a second set of inserts for forming a second set of features of the container being formed of a second material, the first set of inserts being machined to the required shape for fitting within the carrier units and for forming the first set of features and the second set of inserts being machined so as to fit within the carrier units but one or more of the second set of inserts being formed with excess material on surfaces thereof defining said second set of features pending a decision as to the precise shape of said second set of features, whereby once said decision has been made the tool can be completed by machining said excess material to the required shape and assembling the inserts in the mould.
2. A method as claimed in claim 1 in which one or more of the second set of features is changed by replacing one or more of said second set of inserts by one or more further inserts with the excess material thereon machined to different shape.
3. A method as claimed in claim 1 or 2 in which the second set of features comprise static features on the base, lid or spine portions.
4. A method as claimed in any preceding claim in which the second set of features comprises one or more of the following: specific external features, internal graphic features, and a surround for extending around

the periphery or part of the periphery of information storage media held within the container.

5. A method as claimed in claim 4 in which container is provided with a film or sleeve extending around the exterior thereof for receiving an information sheet, the film or sleeve extending over the majority of external faces of the lid portion, base portion and spine portion apart from a band at one end (or both ends) of the container, said band remaining uncovered by said film or sleeve to provide an area in which said specific external features can be formed.
6. A method as claimed in claim 5 in which said band stands proud of the adjacent areas of the external surfaces of the container area (over which the film or sleeve is provided).
7. A method as claimed in any preceding claim in which the container is adapted to hold information storage media in the form of a disk.
8. A method as claimed in claim 7 in which the holding means comprises a hub for releasably engaging the disk via a central aperture therein, the hub being one of said first set of features.
9. A method as claimed in claims 4 and 8 in which the surround comprises a substantially circular or part circular upstand for extending around the periphery of a disk held on said hub.
10. A method as claimed in claim 9 in which the surround has an inner edge adjacent the periphery of the disk which is substantially circular or part circular and an outer edge which is non-circular or partially non-circular.
11. A method as claimed in claim 9 or 10 in which the base portion has a substantially flat, inner surface and said upstand projects from said surface.
12. A method as claimed in claims 4 and 11 in which said inner surface is rectangular, the width (shorter dimension) of the rectangle being of

sufficient size to receive the diameter of said disk and the length (longer dimension) of the rectangle being of sufficient size to receive the diameter of said disk with a space left at one or both ends of the rectangle, said spaces providing an area or areas in which said internal graphics features can be formed.

13. A method as claimed in any preceding claim in which the first material is a hard material whereas the second material is a softer material.
14. A method as claimed in any preceding claim in which the first material is a steel.
15. A method as claimed in any preceding claim in which the second material is a copper alloy.
16. A method as claimed in claim 15 in which, following machining of said excess material, the surfaces of the second set of components defining the shape of the second set of features are provided with a hard coating.
17. A method as claimed in claim 16 in which said coating comprises a nickel or titanium alloy with an additional outer coating of chromium.
18. An injection moulded container formed by a method as claimed in any preceding claim.
19. A plurality of injection moulded containers as claimed in claim 18 each being similar apart from some having a first set of customer specific features and some having a second set of customer specific features (differing from the first set).
20. An injection moulding tool for use in a method of making an injection moulded container for housing information storage media, the container comprising a base portion and a lid portion moveable about a spine portion between an open and a closed configuration and holding means for holding the information storage media within the container, the tool comprising two carrier units each of which is adapted to receive a plurality

of inserts therein which together define a cavity for forming the container: a first set of the inserts for forming a first set of features of the container being formed of a first material and a second set of inserts for forming a second set of features of the container being formed of a second material, the first set of inserts being machined to the required shape for fitting within the carrier units and for forming the first set of features and the second set of inserts being machined so as to fit within the carrier units but one or more of the second set of inserts being formed with excess material on surfaces thereof defining said second set of features pending a decision as to the precise shape of said second set of features, whereby once said decision has been made the tool can be completed by machining said excess material to the required shape and assembling the inserts in the mould.

21. An injection moulding tool as claimed in claim 20 comprising a first set of inserts for forming a first set of features and a plurality of second sets of inserts each second set being for forming a different set of customer specific features.